



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-021
Job Sheet 192285



Part No: D350-636-021

Job Qty: 1 ea

Part Name: AS350/355 - Skidtube - Standard w/ Standard Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D2750-051 REV.H / IIN-D350-636 REV.K IPP REV:A 18.11.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawthorn, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165891



Part: D350-636-021

Job No: 192285

Serial No/Batch: S165891

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA STC

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/19/19	0.00	0.00	Start Up Skid tubes-1		BE
110	Skid tubes	1 pcs		4/19/19	0.00	4.55	Skid tubes-4		BE
120	QC	1 pcs		4/19/19	0.00	0.00	QC10		10 19-04-01
130	QC	1 pcs		4/19/19	0.00	0.00	QC5		10 19-04-01
140	HandFinish	1 pcs		4/19/19	0.00	0.93	HandFinish1		DR 19/04/02
150	QC	1 pcs		4/19/19	0.00	0.00	QC7-2		BE
160	Skid tubes	1 pcs		4/19/19	0.00	4.55	Skid tubes-4		TF BE DAS
170	QC	1 pcs		4/19/19	0.00	0.00	QC10		DR 19-04-15 / 68
180	QC	1 pcs		4/19/19	0.00	0.00	QC5		DR 19-04-15 9-89
190	HandFinish	1 pcs		4/19/19	0.00	0.93	HandFinish2		DR 19/04/16
200	SprayPaint	1 pcs		4/19/19	0.00	0.91	Spray Paint		DR 19/04/27
205	Outsource	1 pcs		4/19/19			ATE003-VC	5	N/A
210	QC	1 pcs		4/19/19	0.00	0.00	QC14		19-4-30
230	HandFinish	1 pcs		4/19/19	0.00	0.93	HandFinish4		19-2 DAS
240	QC	1 pcs		4/19/19	0.00	0.00	QC5		MAY 03 2019 68
250	Packaging	1 pcs		4/19/19	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		4/19/19	0.00	0.00	QC4		DAS
270	Packaging	1 pcs		4/19/19	0.00	0.00	Packaging3-1		21 MAY 08 2019
275	DC	1 pcs		4/19/19	0.00	0.00	DC		21 DAS
280	QC21-FG	1 Ea		4/19/19	0.00	0.00	QC21		21 MAY 08 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-5 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER

POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-5 details). Drill using drill Jig DT8150. 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail BF to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 7- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 38989 8- Grind welds flush as per Dwg D2750

160 - 1- Open up holes using hole saw of Detail BG and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BG, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163445 exp. date: 04/23/19 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 15) A/R Aluminum Rod batch: 38989 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section CS-CS (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5163577 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5166819

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: 5163445 EXP DATE: 19-4-23 5- Coat all exposed fasteners with "LPS Procyon" batch: M132690

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Package as per PPP D350-636-021 Location : FG108

275 - record fwd angle: 67.0 Photocopy blue file and type labels per PPP D350-636-021 CHG 001

DAS
15
9-89

Stat
april, 3rd 2019
7:35am

009678

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	90-Start up Operation	5129373
D2744	Cap	1 pcs (1 ea)	110-Skidtubes	5130291
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes	5152441
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes	5162846
AN3C5A	Bolt 5149186 (12)	34 Ea (34 ea)	230-HandFinish	5156446
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5142457
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5149189
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5079187-1
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5163736
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-HandFinish	5149053
D3537-1	Wearpad	3 pcs (3 ea)	230-HandFinish	5174742
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5058407
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5142098
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-HandFinish	5141967
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-HandFinish	5132951
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5149193
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5104046
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5149669
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5080559
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5059809
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5152649
D3793-5	Wearpad	1 pcs (1 ea)	230-HandFinish	5161972
MS21043-3	Nut	1 Ea (1 ea)	230-HandFinish	5099569
NAS1149C0363R	Washer	2 Ea (2 ea)	230-HandFinish	5135100
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5176381
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging	5129318
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5167203
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5166718

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	3	0
110-Skidtubes	D2744	1	34	0
160-Skidtubes	D2739	1	15	0
	D2743	8	192	0
230-HandFinish	ALS4-1032-225	38	937	0
	AN3C34A	1	14	0
	AN3C5A	34	1,446	0
	AN3C6A	4	164	0
	AN6C44A	4	143	0
	AN8C35A	1	36	0
	D2745	8	240	0
	D3488-3	1	7	0
	D3537-1	3	45	0
	D3631-1	8	285	0
	D3791-1	1	12	0
	D3793-1	1	17	0
	D3793-3	1	13	0
	D3793-5	1	24	0
	MS21043-3	1	966	0
	MS21043-6	4	147	0
	MS21083C8	1	87	0
	NAS1149C0332R	38	5,083	0
	NAS1149C0363R	2	567	0
	NAS1149C0832R	1	349	0
	NAS1515H3L	4	394	0
250-Packaging	AN8C21A	2	111	0
	D2741	1	77	0
	MS21083C8	2	87	0
	NAS1149D0863J	2	123	0

Part Specifications

Specifications could not be found.

Plex 3/20/19 11:46 AM Dart.lajeunesse.marie

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

- NOTES:
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
 - 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
 - 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 - 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
 - 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
 - 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192285 MWS
1903-20

RELEASED
2018 OCT 19
2018-08-25

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-1/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-1/-12/-13/-14); NAS1149C0332R REPLACES AN960C10L (ZN A5-1, B1-1/-12/-13/-14, C7-1/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-1/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

8 7 6 5 4 3 2 1

D

C

B

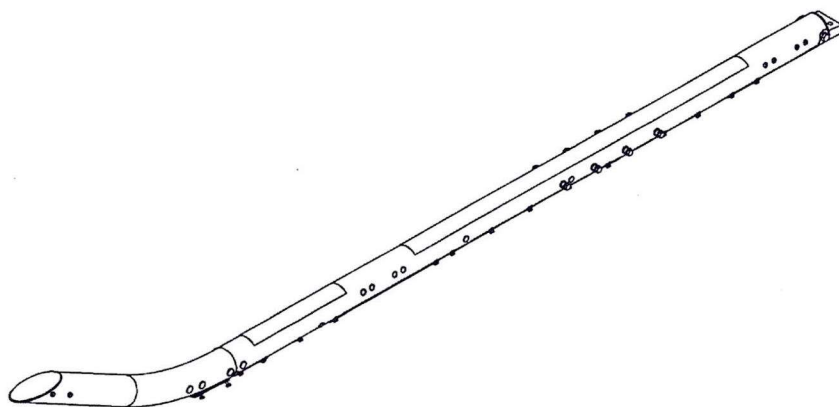
A

D

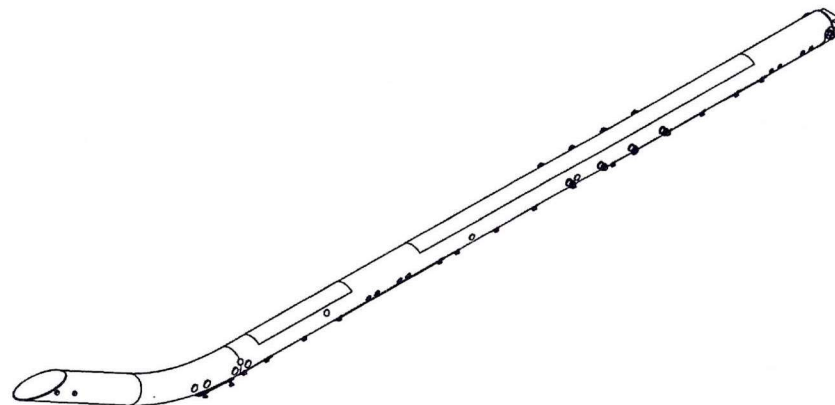
C

B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED

2018 OCT 19
2018 10-19-18

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO. D2750	REV. H
MFG. APPR.	DD		SHEET 2 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

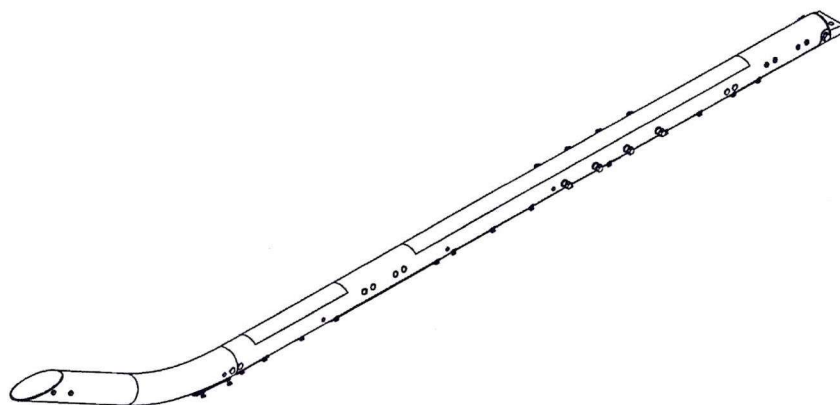
A

D

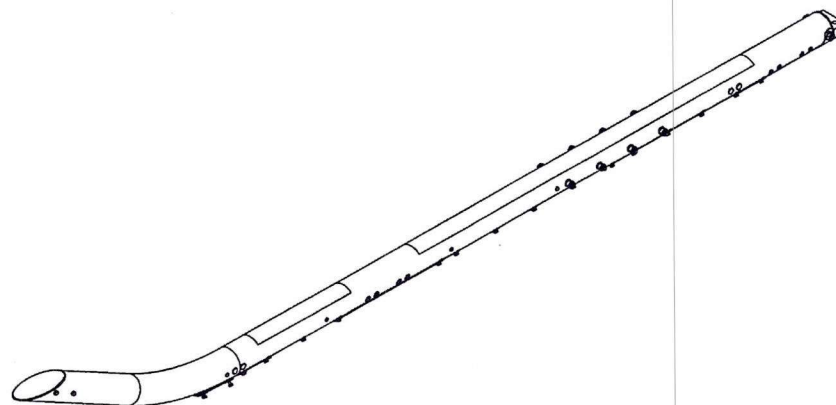
C

B

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



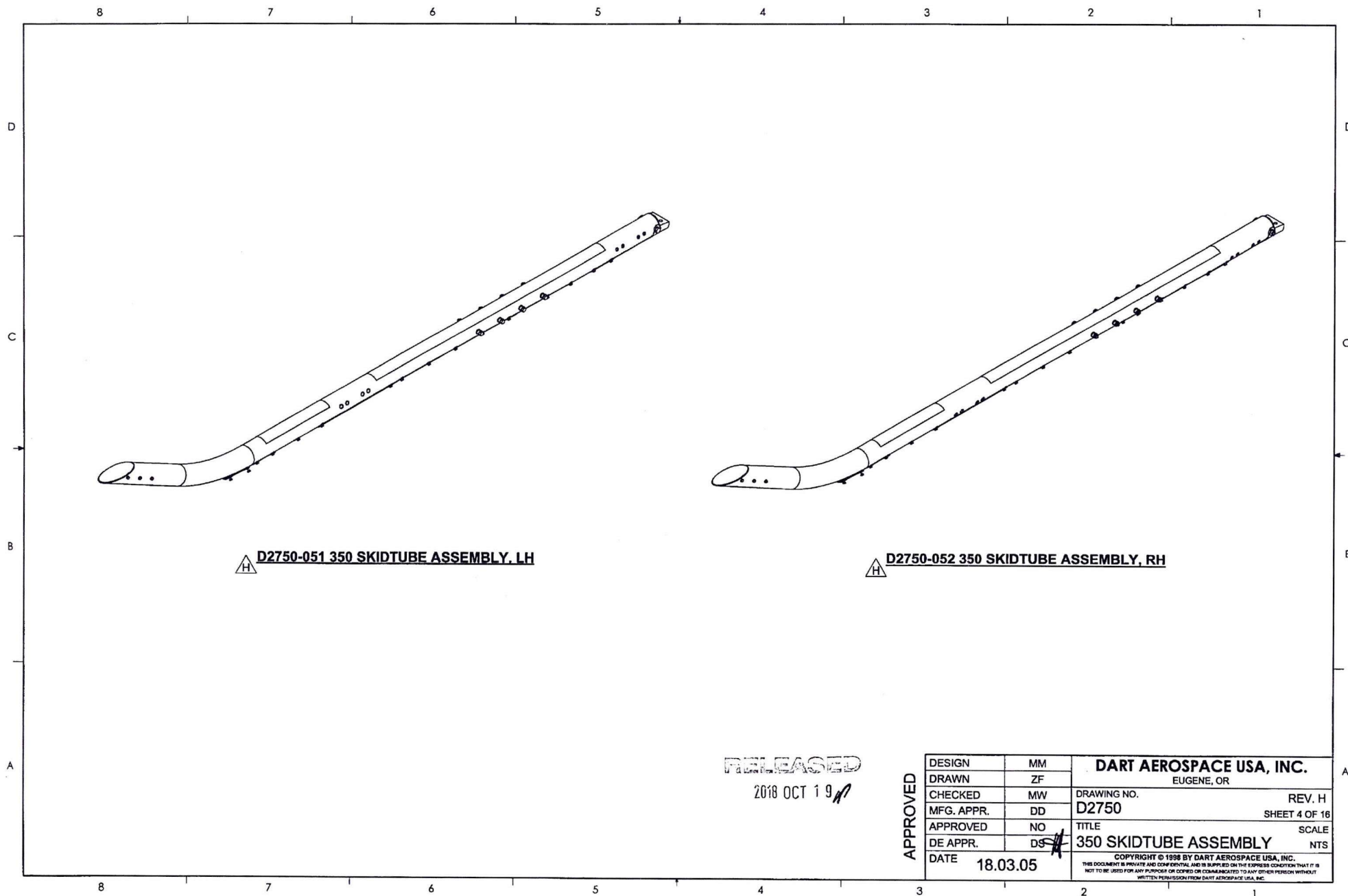
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

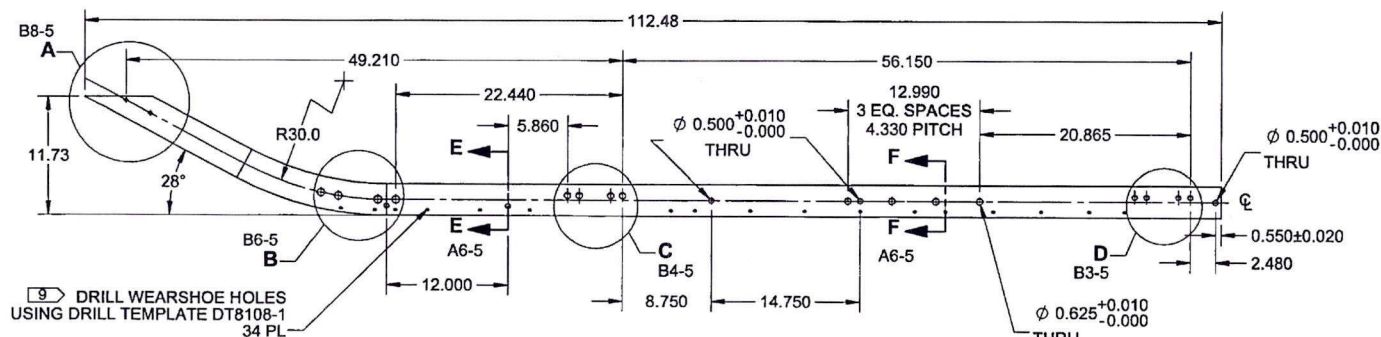
8 7 6 5 4 3 2 1



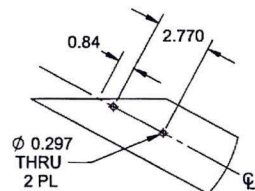
RELEASED
2018 OCT 19

APPROVED

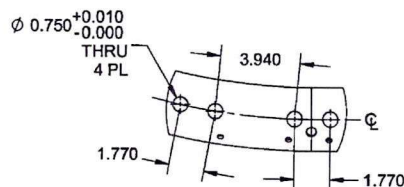
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 4 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



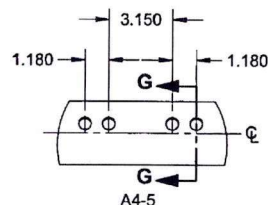
D2750-1 LH SKIDTUBE



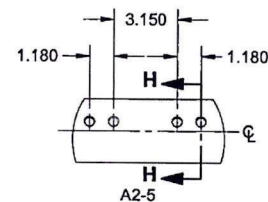
DETAIL A
SCALE 2X



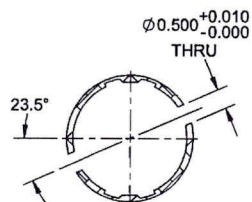
DETAIL B
SCALE 2X



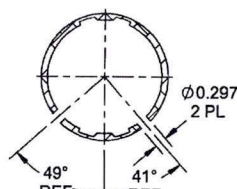
DETAIL C
SCALE 2X



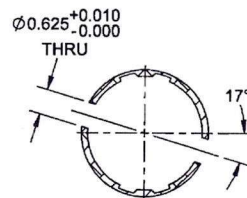
DETAIL D
SCALE 2X



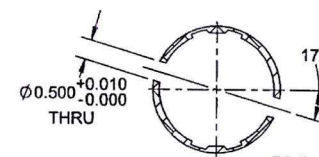
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



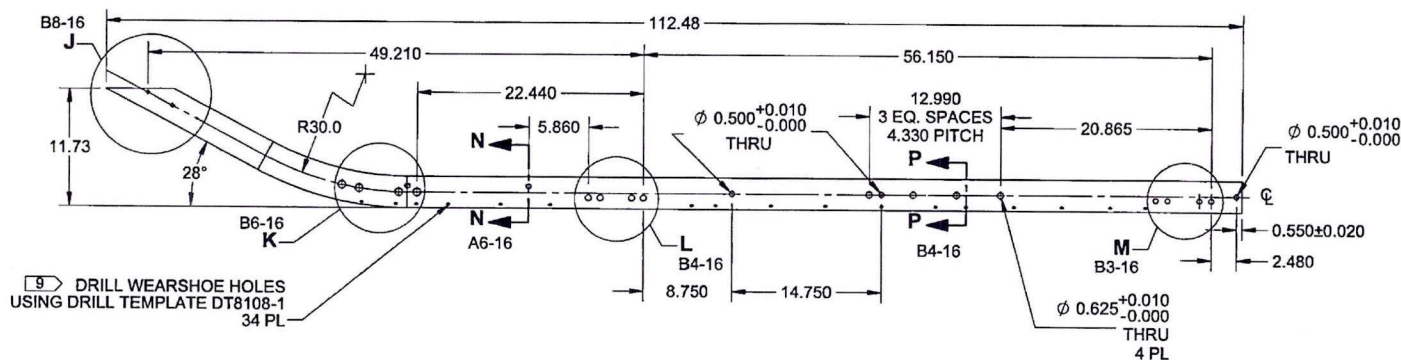
SECTION G-G
SCALE 4X, 4 PL



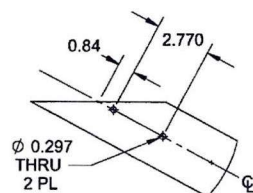
SECTION H-H
SCALE 4X, 4 PL

RELEASED
2010 OCT 19

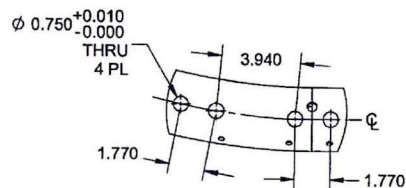
APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 5 OF 1
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



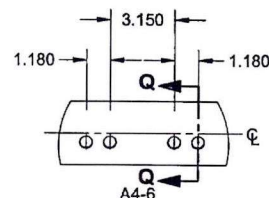
D2750-2 RH SKIDTUBE



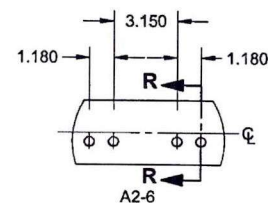
D7-6
DETAIL J
SCALE 2X



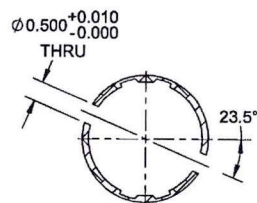
C7-6
DETAIL K
SCALE 2X



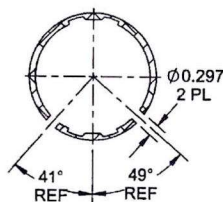
D5-6
DETAIL L
SCALE 2X



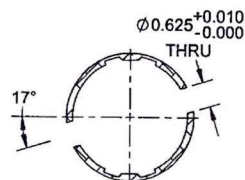
D3-6
DETAIL M
SCALE 2X



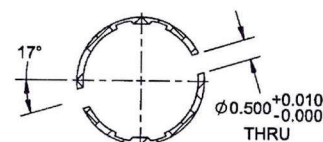
D6-6
SECTION N-N
SCALE 4X, 2 PL



D4-6
SECTION P-P
SCALE 4X, 17 PL



B4-6
SECTION Q-Q
SCALE 4X, 4 PL

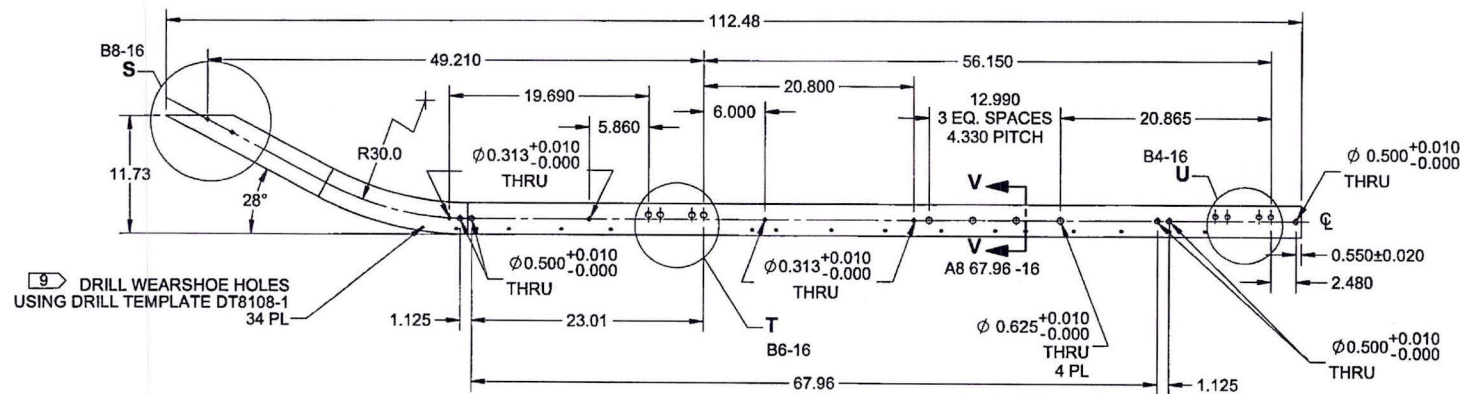


B2-6
SECTION R-R
SCALE 4X, 4 PL

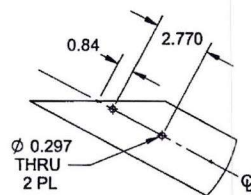
RELEASED

2018 OCT 19

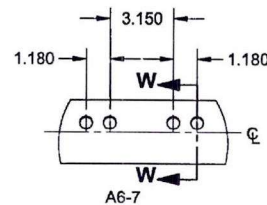
APPROVED	DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO. D2750	REV. H
	MFG. APPR.	DD	SHEET 6 OF 16	
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



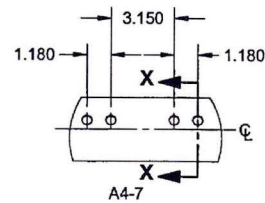
D2750-3 LH SKIDTUBE



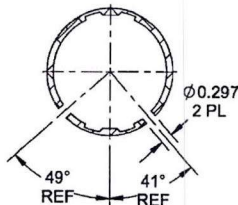
D7-7
DETAIL S
SCALE 2X



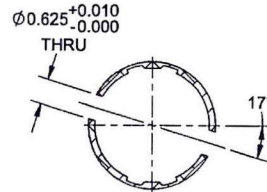
C5-7
DETAIL T
SCALE 2X



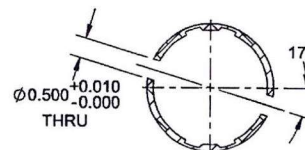
D3-7
DETAIL U
SCALE 2X



D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W
SCALE 4X, 4 PL

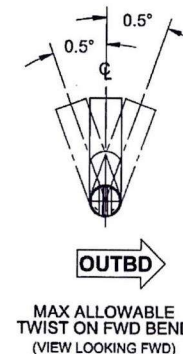
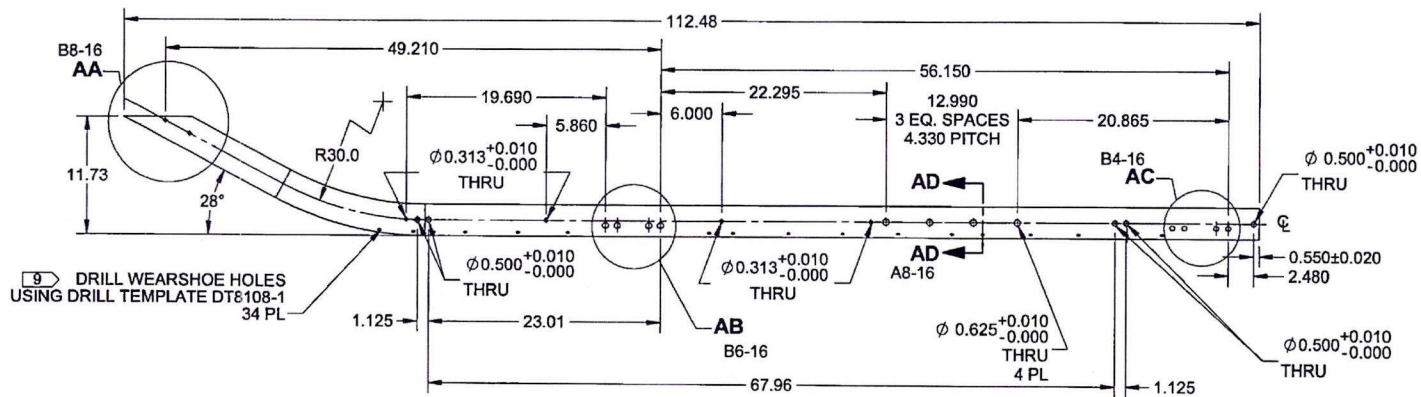


B4-7
SECTION X-X
SCALE 4X, 4 PL

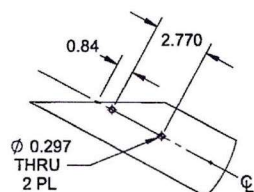
RELEASED
2013 OCT 19

APPROVED

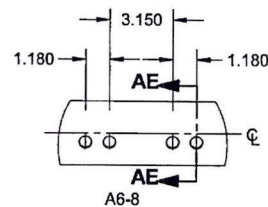
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 7 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



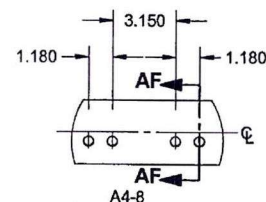
D2750-4 RH SKIDTUBE



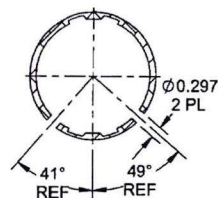
DETAIL AA
SCALE 2X



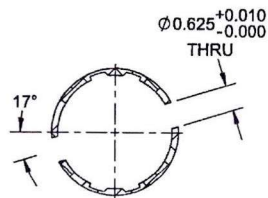
DETAIL AB
SCALE 2X



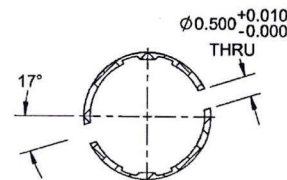
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL

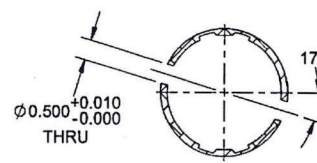
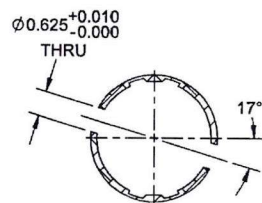
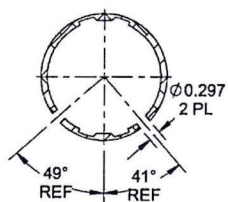
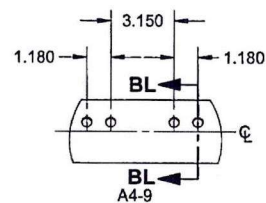
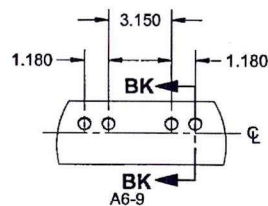
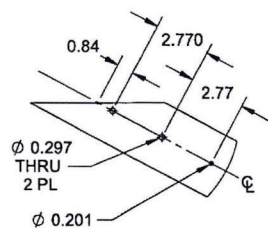
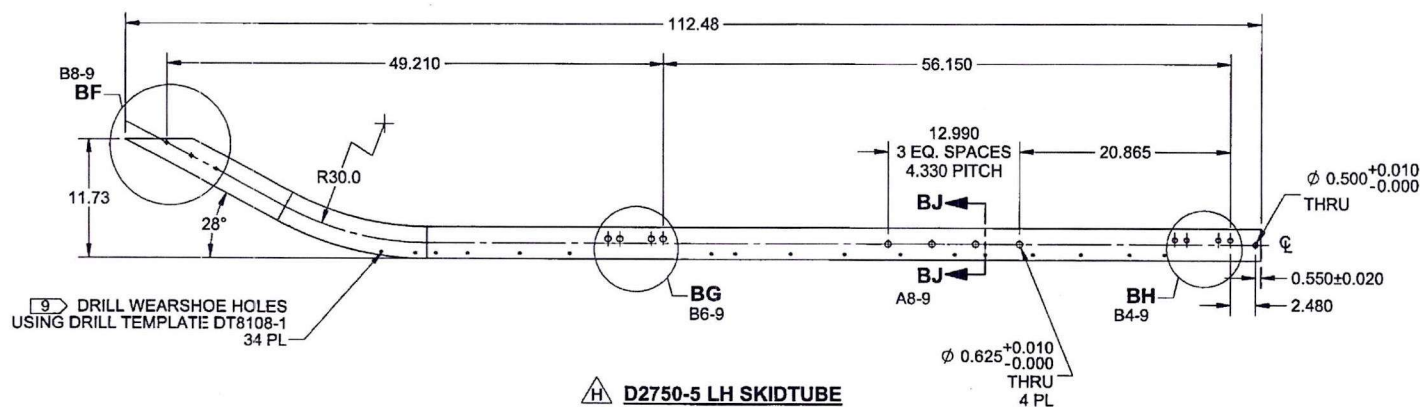


SECTION AF-AF
SCALE 4X, 4 PL

RELEASED
2018 OCT 19

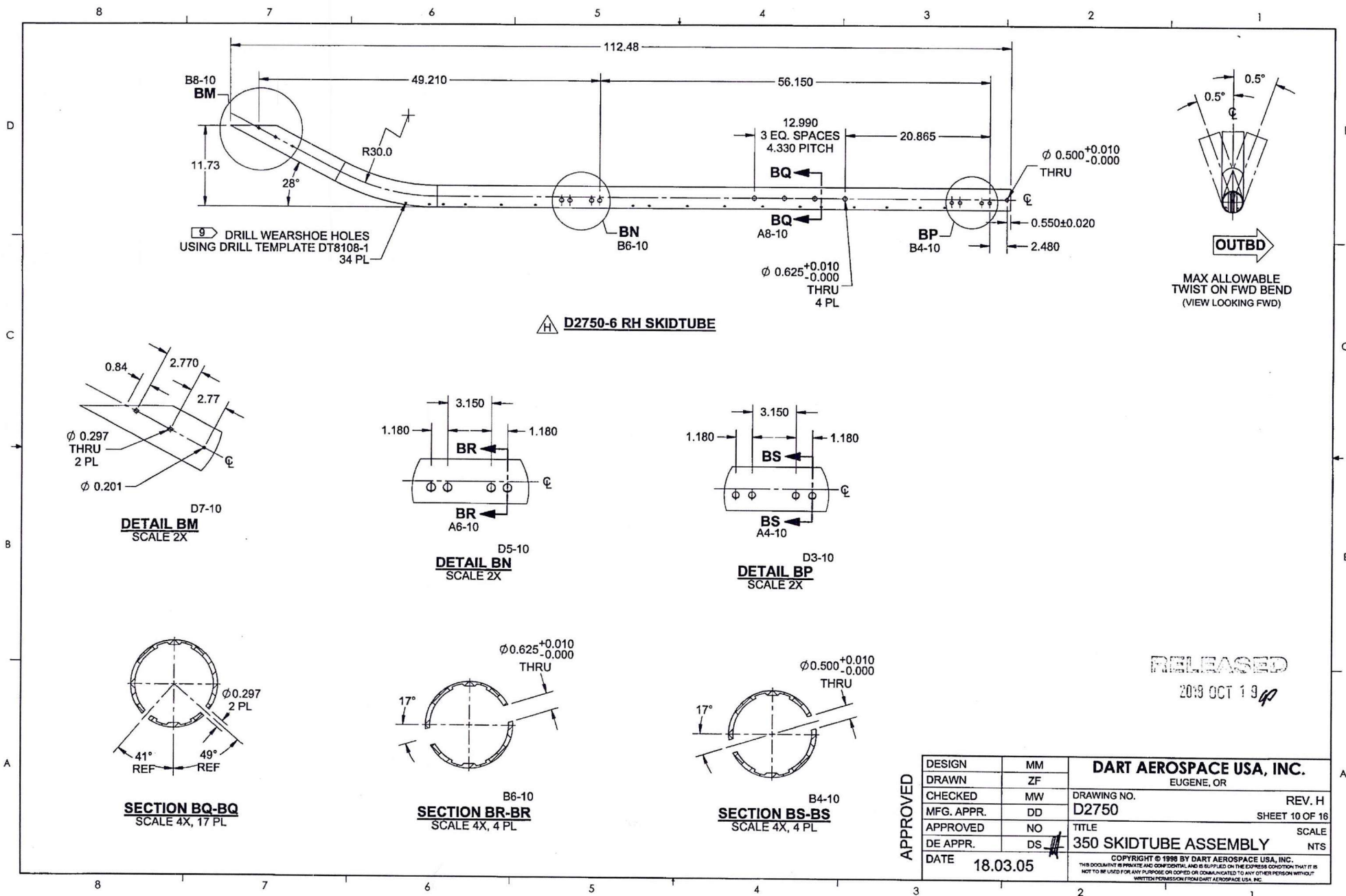
APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 8 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

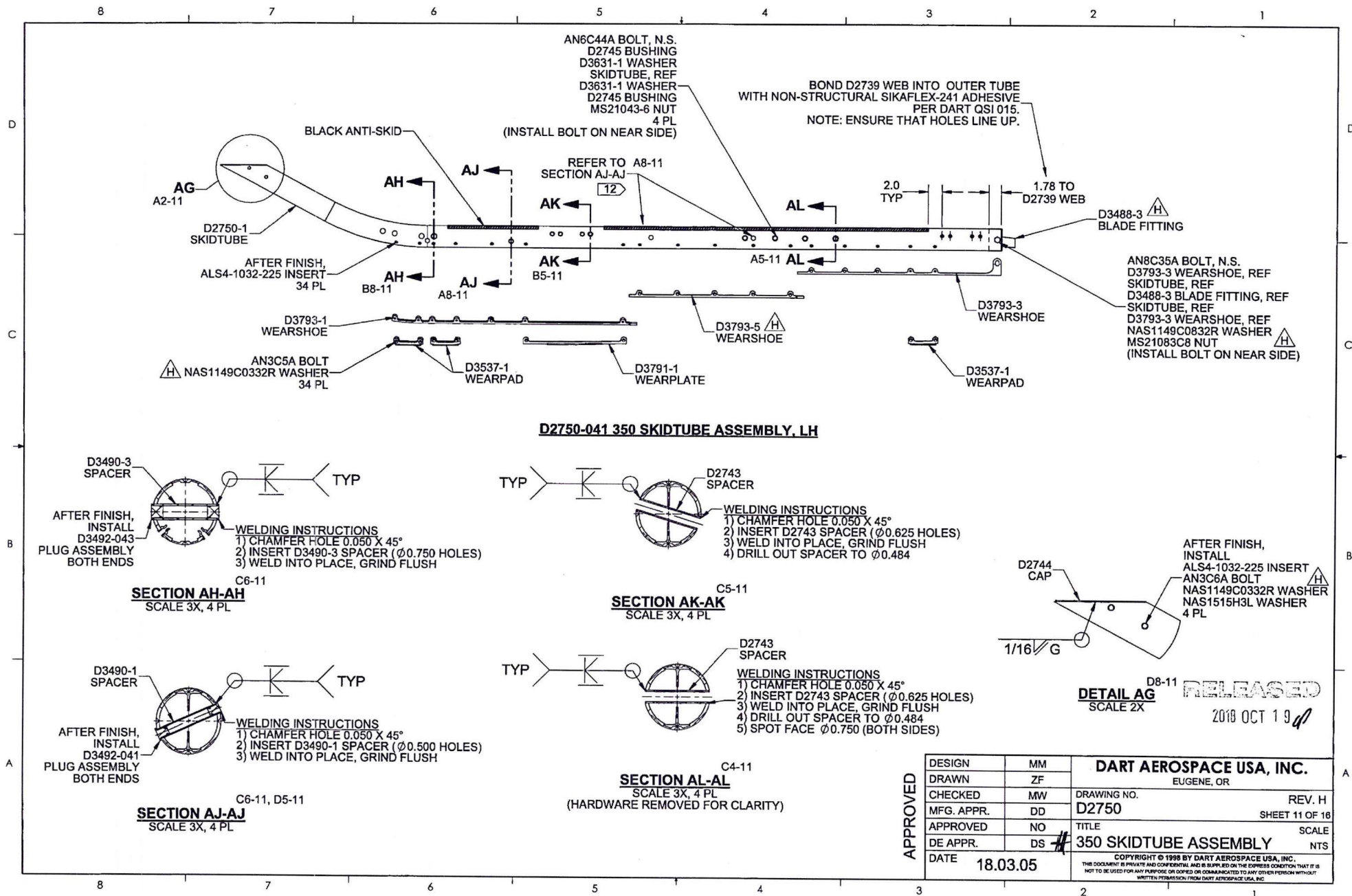


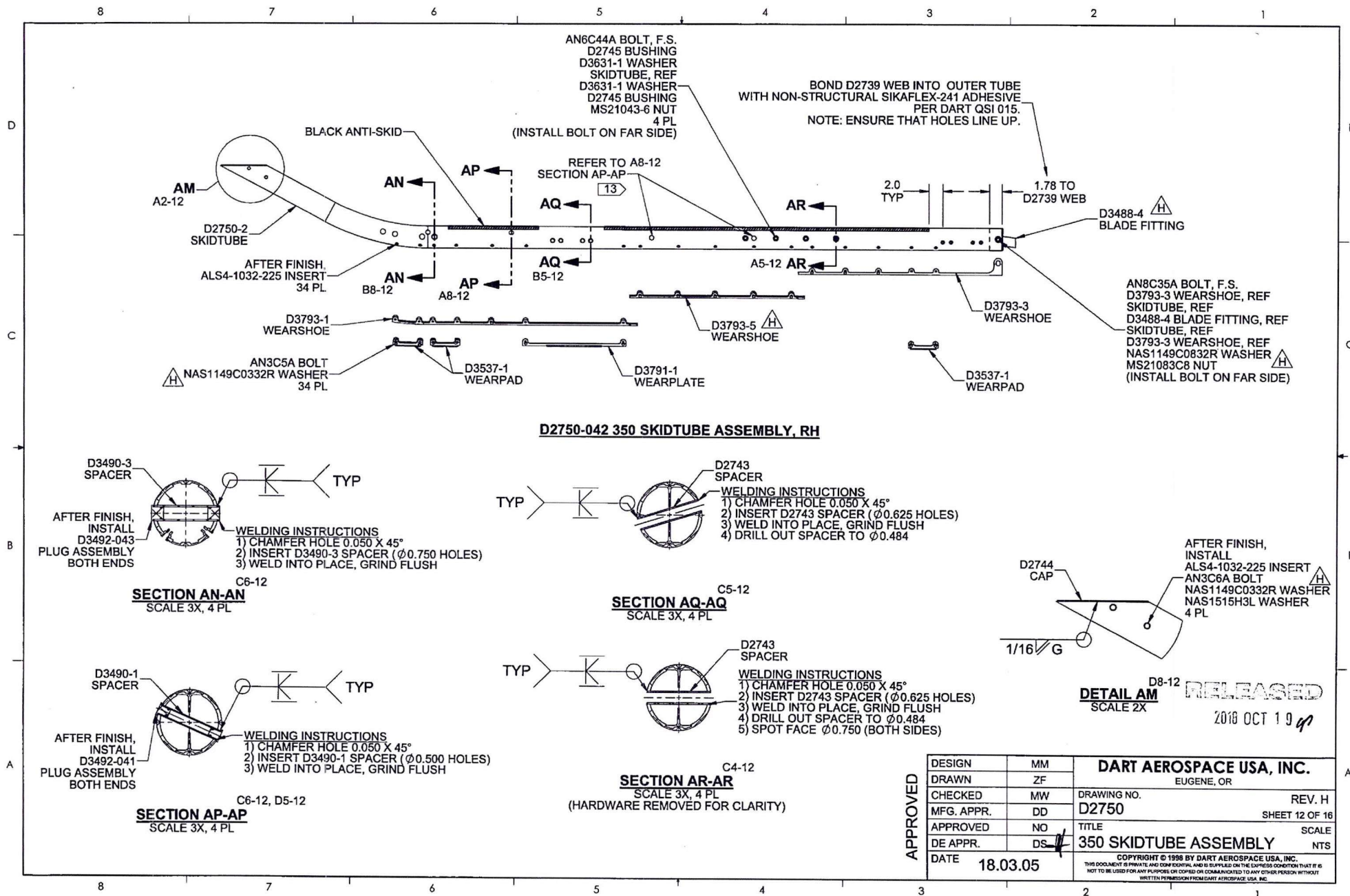
RELEASED
2019 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 9 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

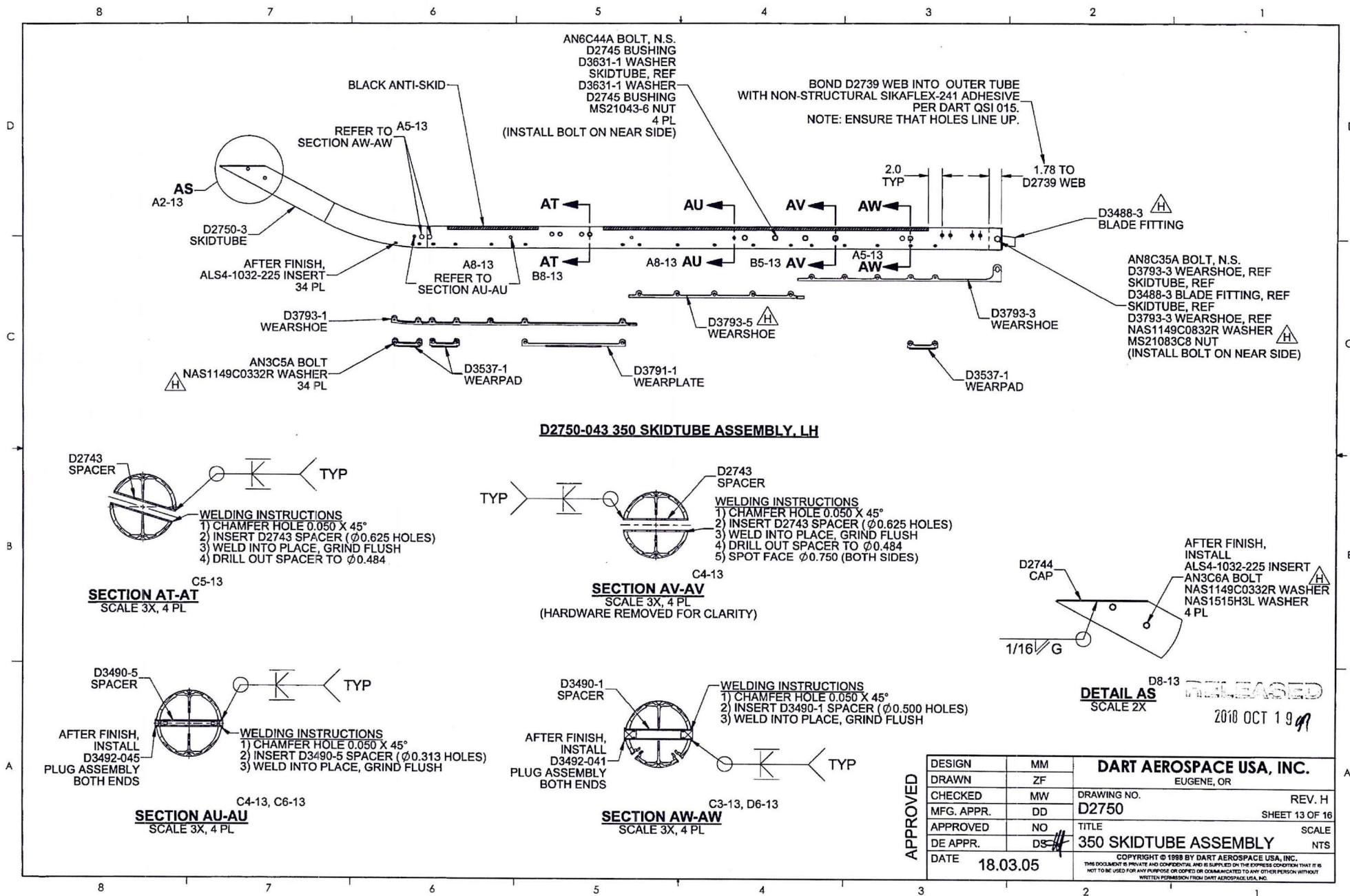


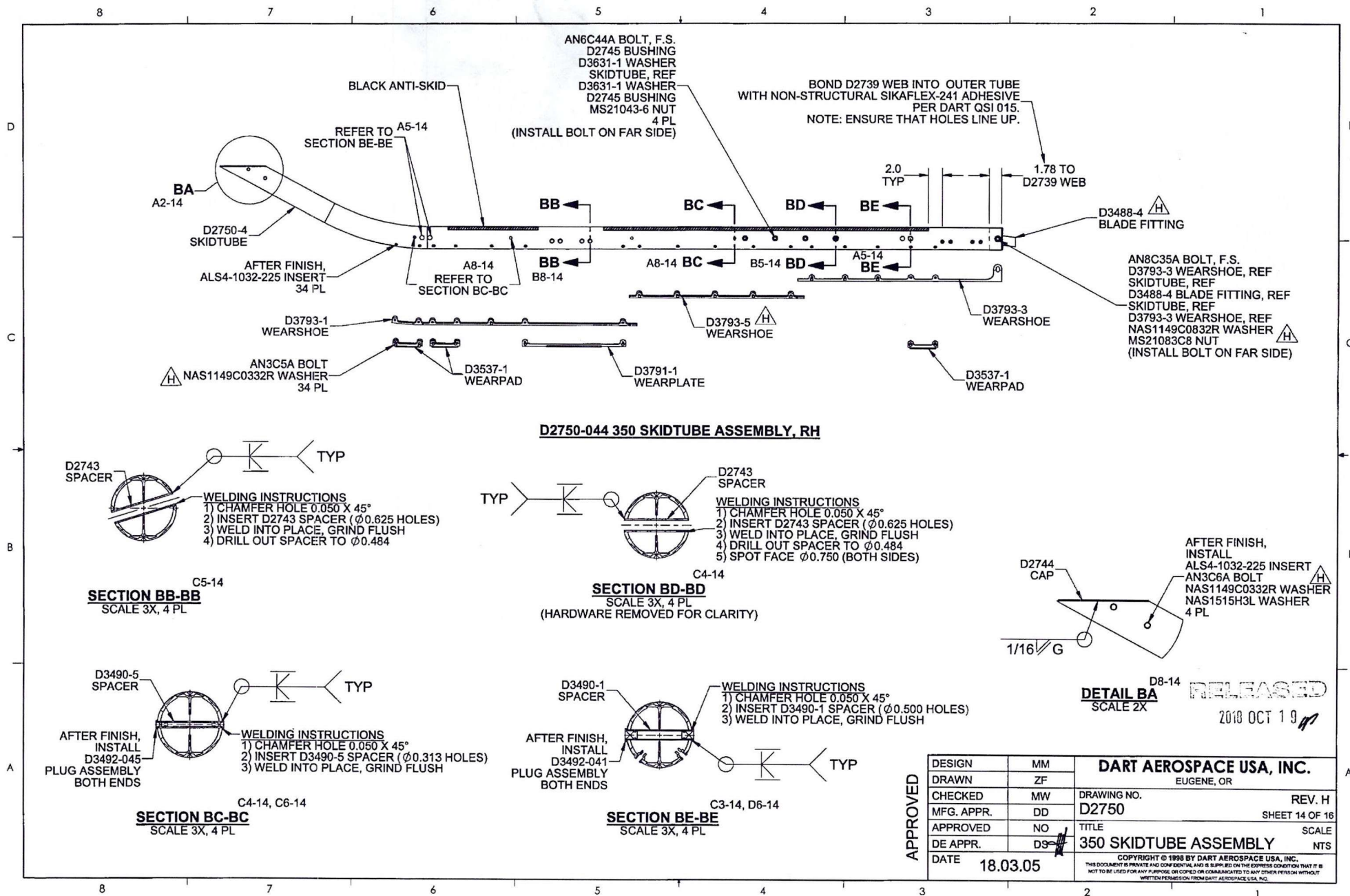
APPROVED	DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 10 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE		18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 12 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 14 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	D3	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8

7

6

5

4

3

2

1

D

C

B

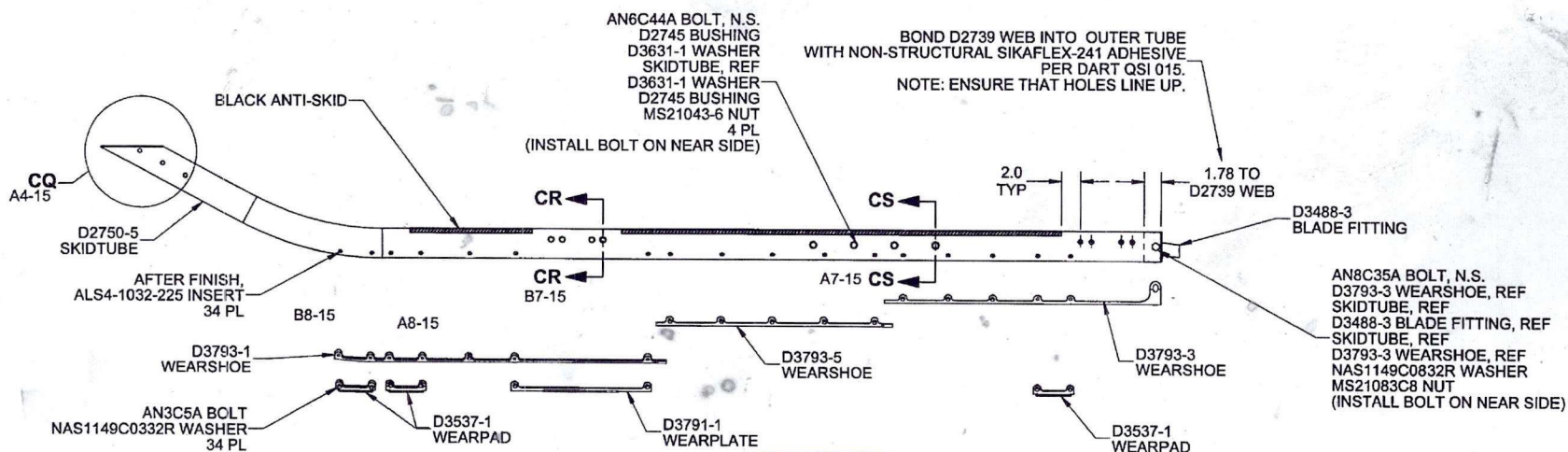
A

D

C

B

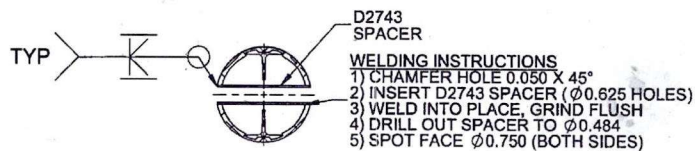
A



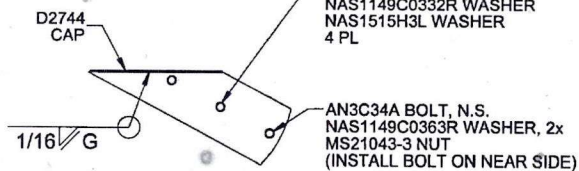
D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR SCALE 3X, 4 PL



SECTION CS-CS SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



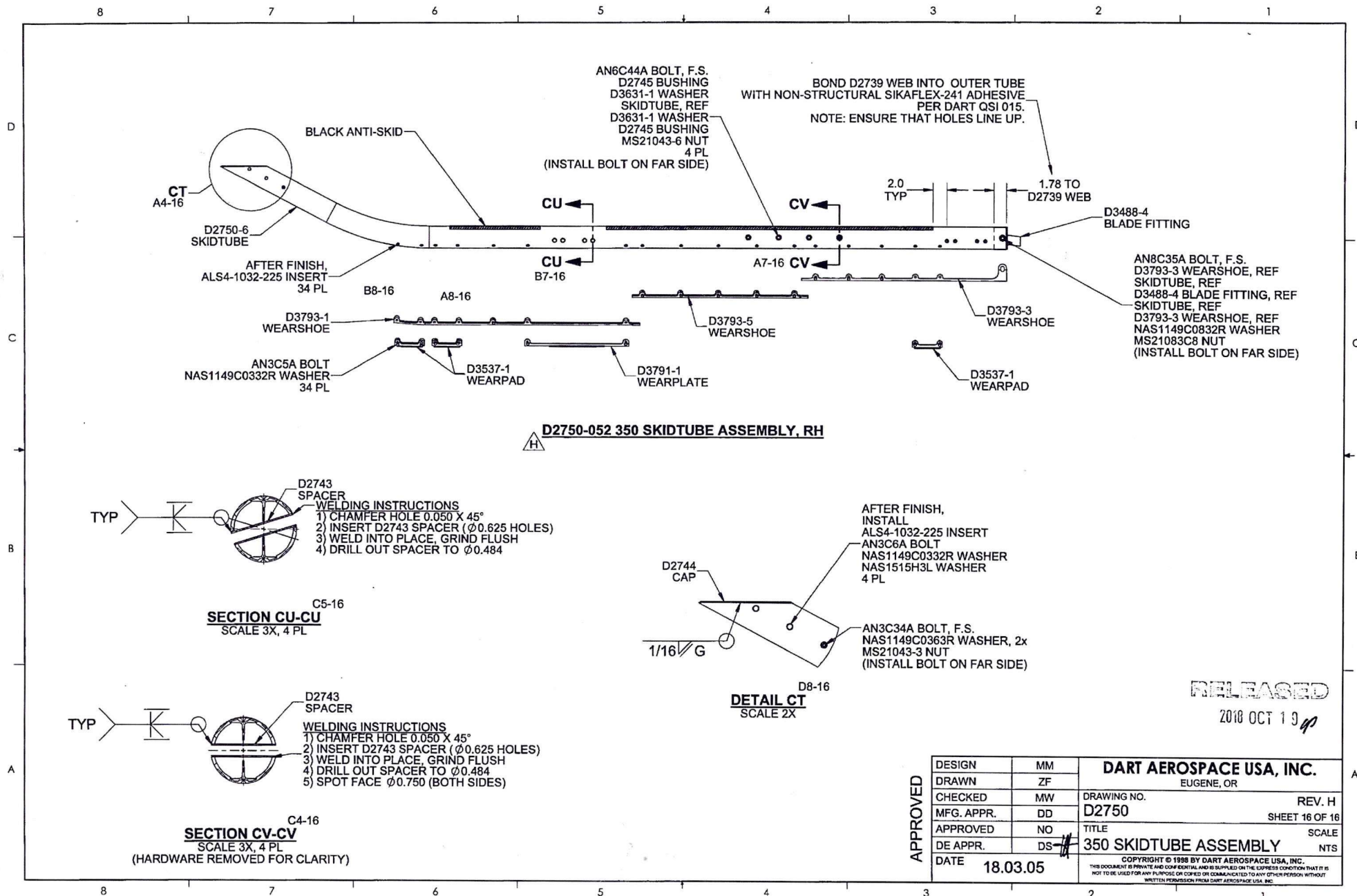
DETAIL CQ SCALE 2X

RELEASED

2018 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 15 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 16 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Change Record

PAGE 1 OF 1

Part Number: D350-636-021/-022

Description: SKIDTUBE INSTALLATION LH/RH, STD

[illegible]